

Work Order ID 63676

Tuesday, November 09, 2010 3:46:23 PM



Page 1

Item ID:	D3535-11	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearshoe				Stop	
Start Date:	11/10/2010	Start Qty: 6.00				
Required Date:	11/24/2010	Req'd Qty: 6.00				
Reference:						

Approvals:	Process Plan:	<u>WVF</u>	Date:	<u>10-11-09</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3535	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3535 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-								
<u>304 .040</u>	Deburr if necessary								<u>6</u>

B 10-11-11

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 10-11-11

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Sol 1/12

76

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3535-11

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 11/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/24/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				<u>6</u>			
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 L2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-11	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00				<u>6</u>			
Quality Control	Memo	0.00							
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				<u>6</u>			
Powder Coating	Memo START TIME: <u>12:00</u> FINISH TIME: <u>12:30</u> <input type="checkbox"/> OVEN TEMPERATURE:	0.00							

58101115

11/11/10

6 BK 10 11-17.

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Page 3

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Setup Start



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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 7 Ml

10/11/17

6 0

170

Identify as per dwg & Stock Location:

FR 19

0.00



Packaging

Memo

0.00

Packaging

6 BR 10-11-17.

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/17

MF

10-11-17

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Picklist Print

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Page 1

Work Order ID: 63676



Parent Item: D3535-11



Parent Item Name: Wearshoe

Start Date: 11/10/2010

Required Date: 11/24/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	165.0000	0.7015	4.430526			



304/316 .040 Sheet



B10-11-11

Location

Loc Qty

Loc Code

MAT	161	
115762	10.2	
115953	150.8	
MAT20	4	
113062	1.398	
115440	2.602	

115953

6

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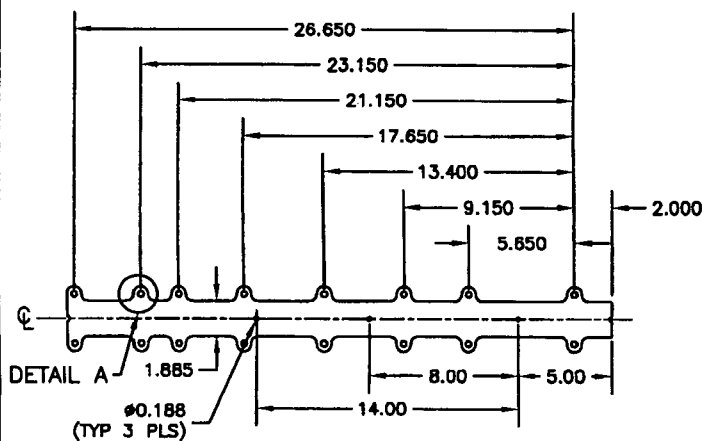
NOTE: Date & initial all entries

DART

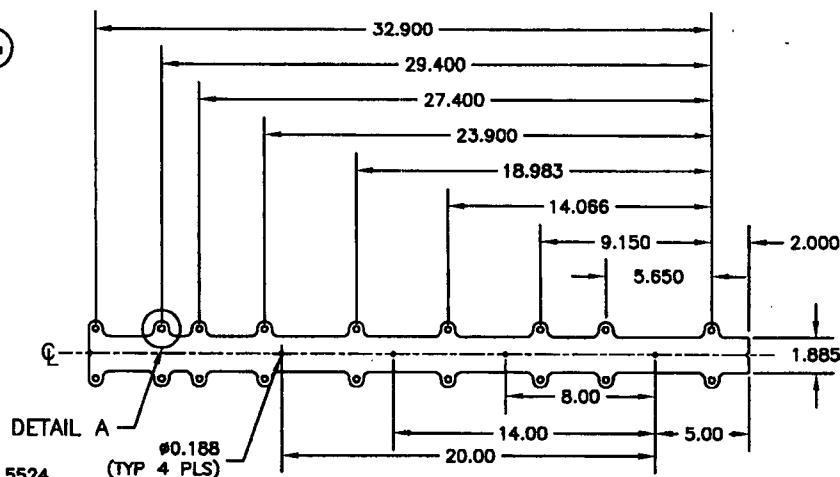
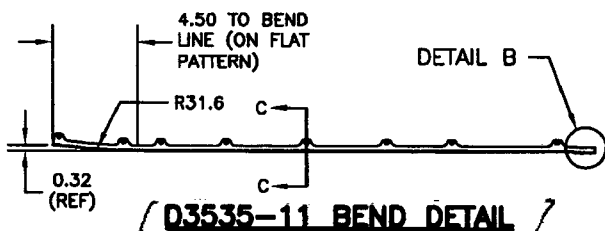
RELEASED

07.04.24

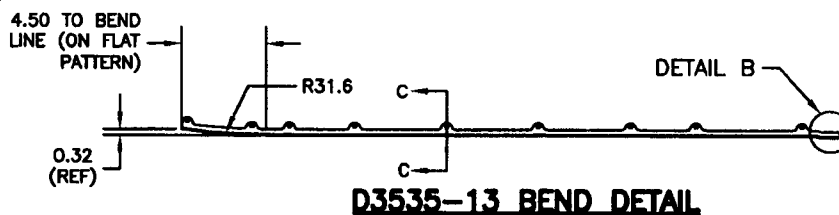
#62676



D3535-11F FLAT PATTERN



D3535-13F FLAT PATTERN



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
#	#	D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

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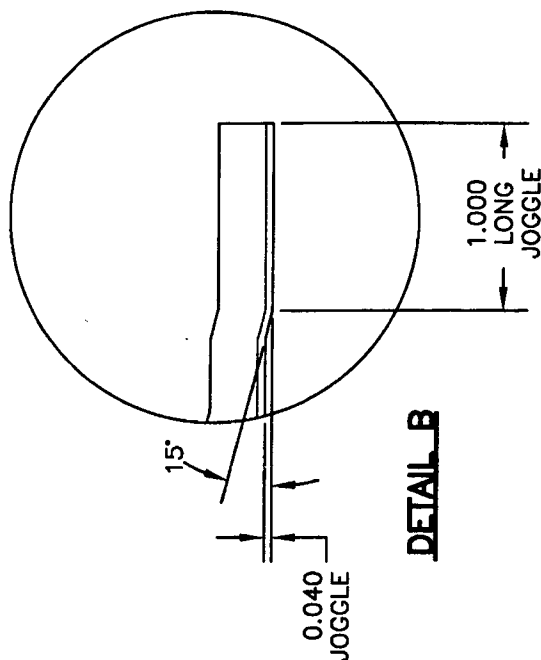


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

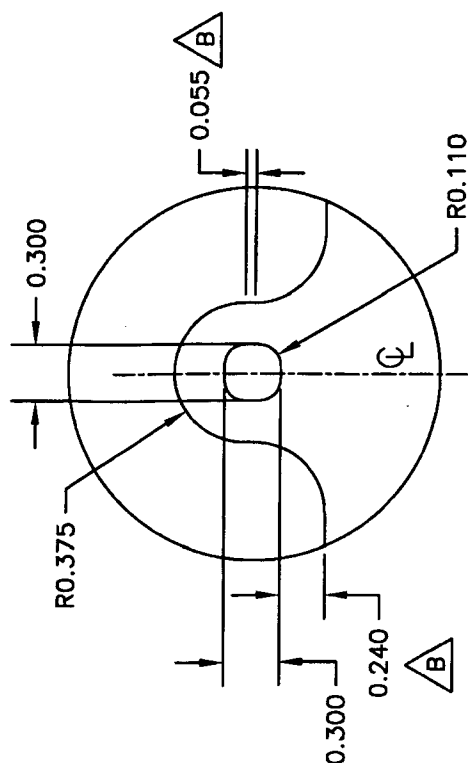
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07.04.24

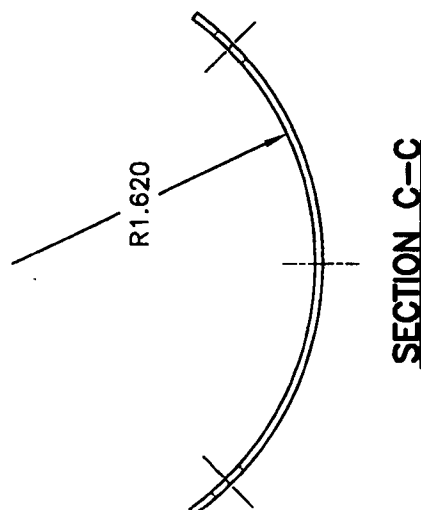
#636776



DETAIL B



DETAIL A



SECTION C-C

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DART AEROSPACE LTD		Work Order: 63676
Description: Wearshoe		Part Number: D3535-11
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.010	4.997	X		VIB02	
8.00	+/-0.010	8.00	X		V	
14.00	+/-0.010	14.00	X		V	
21.150	+/-0.010	21.150	X		V	
26.650	+/-0.010	26.650	X		V	
5.650	+/-0.010	5.650	X		V	
Ø0.188	+0.005/-0.001	.191	X		V	
0.300	+/-0.010	.304	X		V	
0.300	+/-0.010	.305	X		V	
0.038	+/-0.010	.037	X		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-11-11	Date: 10/11/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/DD	

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